

CLAIMS

- Sub B4 T5*
1. Device for manufacturing containers, in particular bottles, made of a thermoplastic by blow molding or stretch-blow molding of a preheated preform, the said device including at least one mold (1) consisting of two half-molds (2) respectively supported by two mold carriers (3) which can move one with respect to the other,
- 10 characterized in that each half-mold (2) comprises a shell holder (9) supported by the respective mold carrier (3) and a shell (7) which is provided with a half-impression (8) of the container to be obtained and which can be removably fastened to its shell holder (9) by quick-fixing means (19-23), the shell (7) and the shell holder (9) being of complementary shapes in order to be in at least partial mutual thermal-conduction contact while the pipes and connections for the circulation of cooling and/or heating fluids (11, 12) are provided exclusively in the shell holder.
- 15 2. Device according to Claim 1, characterized in that the mating faces (14, 15) of the shell (7) and of the shell holder (9) are in total thermal-conduction contact.
- 20 25. 3. Device according to Claim 1, characterized in that the mating faces (14, 15) of the shell (7) and of the shell holder (9) are in partial thermal-conduction contact by leaving regions of limited thermal conduction.
25. 4. Device according to ~~any one of Claims 1 to 3~~, characterized in that the mutually contacting mating faces (14, 15) of the shell (7) and of the shell holder (9) are approximately semicylindrical surfaces of revolution with an axis approximately parallel to the axis of the impression (8) of the container to be manufactured.
- 30 35. 5. Device according to ~~any one of Claims 1 to 4~~, characterized in that the mutually contacting mating faces (14, 15) of the shell and of the shell holder are

provided with axial mutual-positioning means (16, 17).

6. Device according to Claim 5, characterized in that the axial mutual-positioning means comprise a system of one or more mating ribs (16) and grooves (17) extending circumferentially.

7. Device according to ~~any one of Claims 1 to 6~~, characterized in that the means (19-23) for quickly fixing the shell (7) to the shell holder (9) are provided on their respective parting faces (13, 18).

8. Device according to ~~Claims 4 and 7~~, characterized in that the means (19-23) for quickly fixing the shell and the shell holder are located on their respective edges parallel to the axis of the impression.

9. Device according to Claim 8, characterized in that the quick-fixing means (19-23) comprise, on one side, at least one stop for positioning the parting face of the shell with respect to the parting face of the shell holder and, on the other side, quick-screwing means (23) on the parting face (18) of the shell holder (9) with a clamping surface (21) projecting from the parting face (19) of the shell.

10. Device according to Claim 9, in which the mold carriers are rotationally pivoted with respect to each other in order to form a "jackknife"-type mold, characterized in that at least one stop is located on the pivot (4) side of the mold carriers (3) and the quick-screwing means are located on the opposite side.

11. Device according to ~~any one of the preceding claims~~, characterized in that the shell holder (9) is also provided with members (24) for guiding the half-molds in order to close the mold.

12. Device according to ~~any one of the preceding claims~~, characterized in that at least one of the shell holders is equipped with pressure-compensating means suitable for maintaining the sealed closure of the mold during blow molding.

13. Device according to ~~any one of the preceding claims~~, characterized in that the shell holders (9) are equipped with a number of fluid pipes, by virtue of which

it is possible to create suitable circuits for a given manufacture with a given impression.

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